

Work Order ID 158643

Tuesday, March 28, 2017 1:42:20 PM

158643

Page 1

Item ID: D4842-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: URF 16-692 **POSITIVE RECALL** Stop ***NS2***
 Item Name: Lower Cutter Assembly
 Start Date: 4/11/2017 Start Qty: 2.00 ***2*** Cust Item ID: **F.A.I.R. COMPLETION**
 Required Date: 4/12/2017 Req'd Qty: 2.00 ***2*** Customer: **REQUIRED**
 Reference: SCHEDULED/C **CONCESSION 400000061786**

Approvals: Process Plan: **OK** Date: MAR 28 2017 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4842	REV B U/R OK 9/17/3/28

110	Pick Kit	0.00							APR 10 2017
110									
Packaging	Memo	0.16							
Packaging									

120		0.00							
120									
Small Fab	Memo	1.71							
Small Fab	Assemble as per dwg and apply loctite 598 on all faying surfaces.								
	A/R LOCTITE 598: 136701								

130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.04							
Quality Control									

- * ARC MUST be created by QA
- * ARC MUST contain concession Number
- * All parts MUST be identified w/ concession Number
- * FAIR MUST be created

Rush
U/R

**MATERIAL CERTIFICATION
REQUIRED**

**F.A.I.R. COMPLETION
REQUIRED**

QC APPROVAL

ONLY

② 11-04-07
21.8 mm.

POSITIVE RECALL

EFFECTIVE 17/4/3 AUTH **6**
RELEASED **DAS** DATE 17-04-07

(concession 400000061786)

DA
36
9-8

DAS
9
9-89

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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Page 2

Item ID: D4842-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: URF 16-692 Stop ***NS2***
Item Name: Lower Cutter Assembly
Start Date: 4/11/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 4/12/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference: SCHEDULED/C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>CCK 045</u>	0.00							
140					DAS				DAS
Packaging	Memo	0.02			6	2			LB 41
Packaging					8-89				SM 9-89
									APR 09 2017
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.20							
Quality Control									

17/4/10 JH

APR 10 2017

DAS
21
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
300 300 30 30 300 300								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : _____									

Tuesday, March 28, 2017 1:42:25 PM

158643

D4842-041

Start Date: 4/11/2017**Required Date:** 4/12/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 13.04.30 NEW ISSUE DD VERF:JLM IPP
REV:B 13.11.01 AS PER DWG REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4839-1 *D4839-1* Blade		Manufactured	No				Each	3.0000		4			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				CCK128			3						
				141328			3						
D4842-1 *D4842-1* Lower Cutter Deflector		Manufactured	No				Each	7.0000		2			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				CCK035			7						
				140905			7						
D4842-3 *D4842-3* Lower Cutter Body, LH		Manufactured	No				Each	6.0000		2			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				qrtn			6						
				140906			6						
D4842-4 *D4842-4* Lower Cutter Body, RH		Manufactured	No				Each	2.0000		2			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				qrtn			2						
				142317			2						

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified ☐	☐	Past Due	☐				

Picklist Print

Tuesday, March 28, 2017 1:42:25 PM

Page 2

Work Order ID: 158643

158643

Parent Item: D4842-041

D4842-041

Parent Item Name: Lower Cutter Assembly

Start Date: 4/11/2017

Required Date: 4/12/2017

Start Qty: 2.00

Required Qty: 2.00

MS21042L08

Purchased

No

Each

571.0000

12

MS21042L08

Nut

**

DAS
6
9-89
APR 04 2017

Location

Loc Qty

Loc Code

GA

410

m135274

18

m135978

392

ST303

161

m136975

111

m137061

50

MS27039-08-19

Purchased

No

Each

285.0000

12

MS27039-08-19

Screw

**

DAS
6
9-89
APR 04 2017

Location

Loc Qty

Loc Code

GA

62

m135948

62

over006

100

m137061

100

ST277

123

m136851

73

m136975

50

NAS1149FN832P

Purchased

No

Each

1,634.000

24

NAS1149FN832P

Washer

**

DAS
6
9-89
APR 04 2017

Location

Loc Qty

Loc Code

GA

347

M135058

232

M136182

115

ST263

1287

M136866

1287

Tuesday, March 28, 2017 1:42:25 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

MS21042L08
LOCKNUT

NAS1149FN832P WASHER

D4839-1 BLADE

D4842-3 LOWER
CUTTER BODY LH

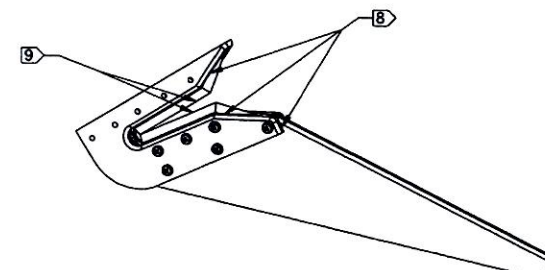
MS27039-0819 SCREW

NAS1149FN832P WASHER

D4842-4 LOWER
CUTTER BODY RH

D4842-1 LOWER CUTTER DEFLECTOR

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4842-041	LOWER CUTTER ASSY
1	2	D4839-1	BLADE
2	1	D4842-1	LOWER CUTTER DEFLECTOR
3	1	D4842-3	LOWER CUTTER BODY LH
4	1	D4842-4	LOWER CUTTER BODY RH
5	6	MS21042L08	LOCKNUT
6	6	MS27039-0819	SCREW
7	12	NAS1149FN832P	WASHER
8	A/R	LOCTITE 598	RTV SEALANT



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 158643

MAR 28 2017

D4842-041 LOWER CUTTER ASSEMBLY

UNDER REVIEW

URF 16-692 WM

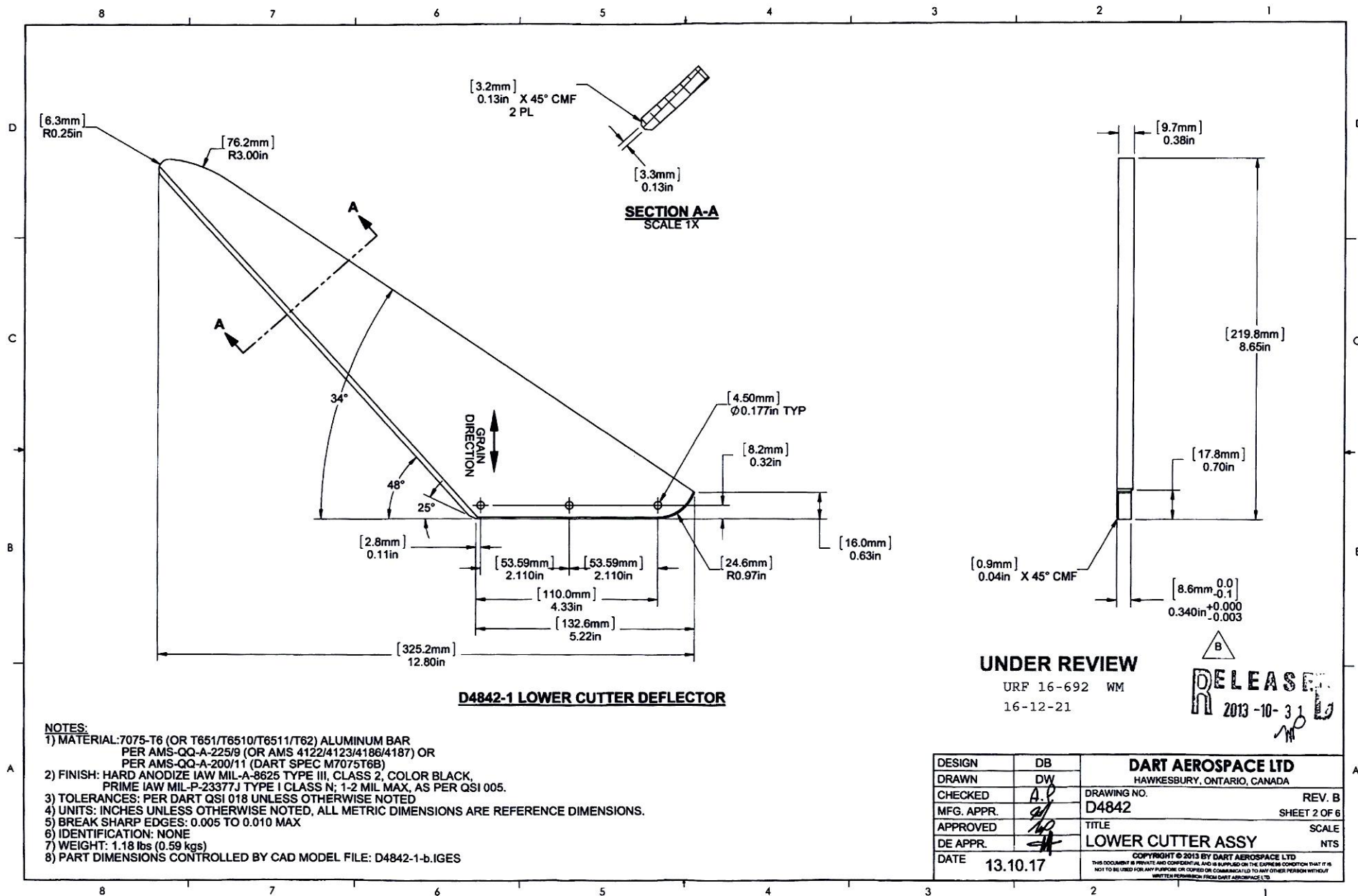
16-12-21

RELEASED
2013-10-31

B	CORRECT TOLERANCES (ZN B1-2) (ZN B1-3, D2-3) (ZN B7-5, D7-5)	DW	13.10.17
A	NEW RELEASE	DB	13.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED	A.P.	DRAWING NO.	REV. B
MFG. APPR.	at	D4842	SHEET 1 OF 6
APPROVED	at	TITLE	SCALE
DE APPR.	at	LOWER CUTTER ASSY	NTS
DATE	13.10.17	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4842-041", AGUSTA WESTLAND KIT NUMBER "TBD", REVISION, BATCH NUMBER AND MANUFACTURE DATE, USING AN X-TENSION STAMP, AS PER QSI 044 METHOD 6.2
- 7) WEIGHT: 2.79 lbs (1.26 KGS)
- 8) APPLY RTV SEALANT TO ALL FAYING SURFACES UPON ASSEMBLY
- 9) CUTTING EDGE INTENDED TO BE SHARP. DO NOT BREAK SHARP EDGE.



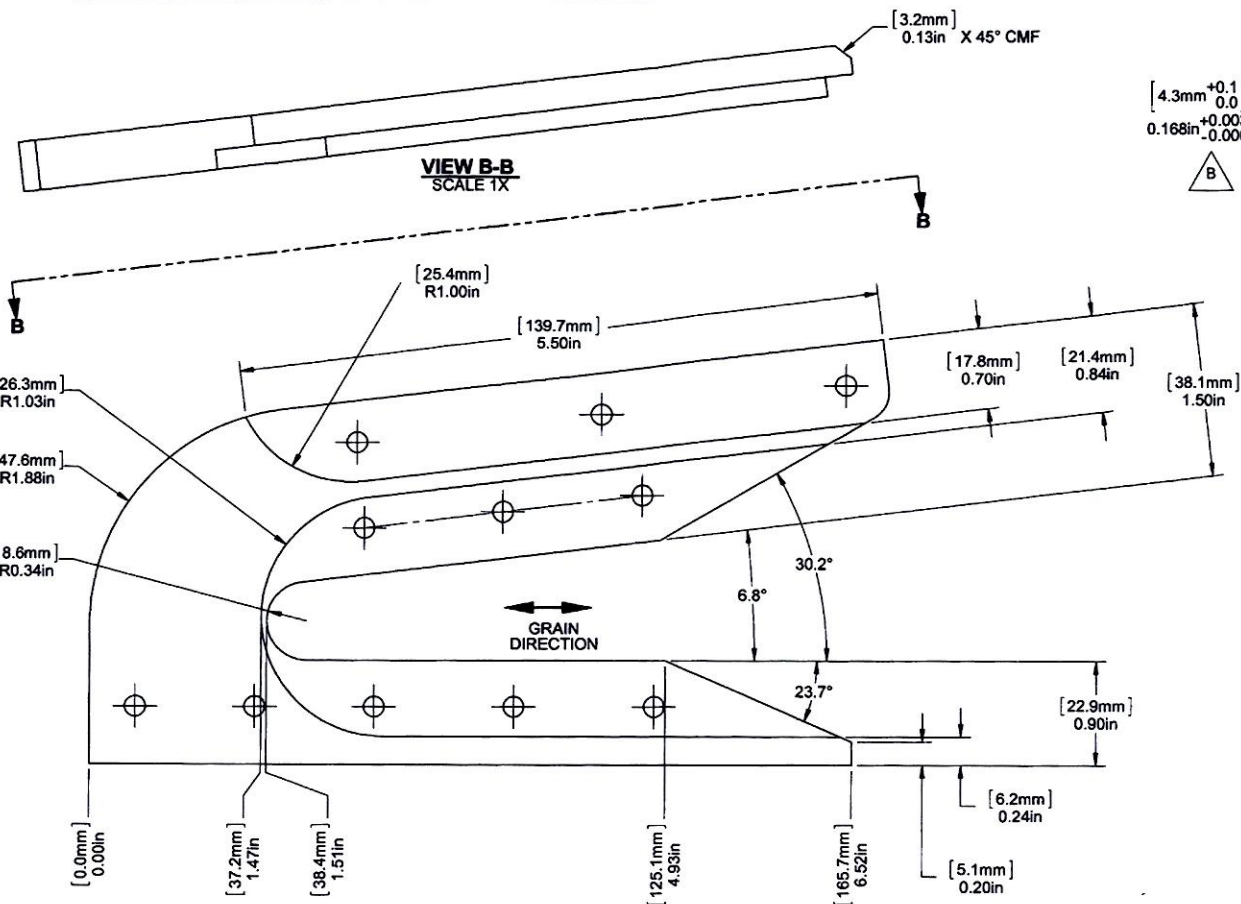
8 7 6 5 4 3 2 1

D

C

B

A



VIEW B-B
SCALE 1X

D4842-3 LOWER CUTTER BODY LH

UNDER REVIEW

URF 16-692 WM
16-12-21

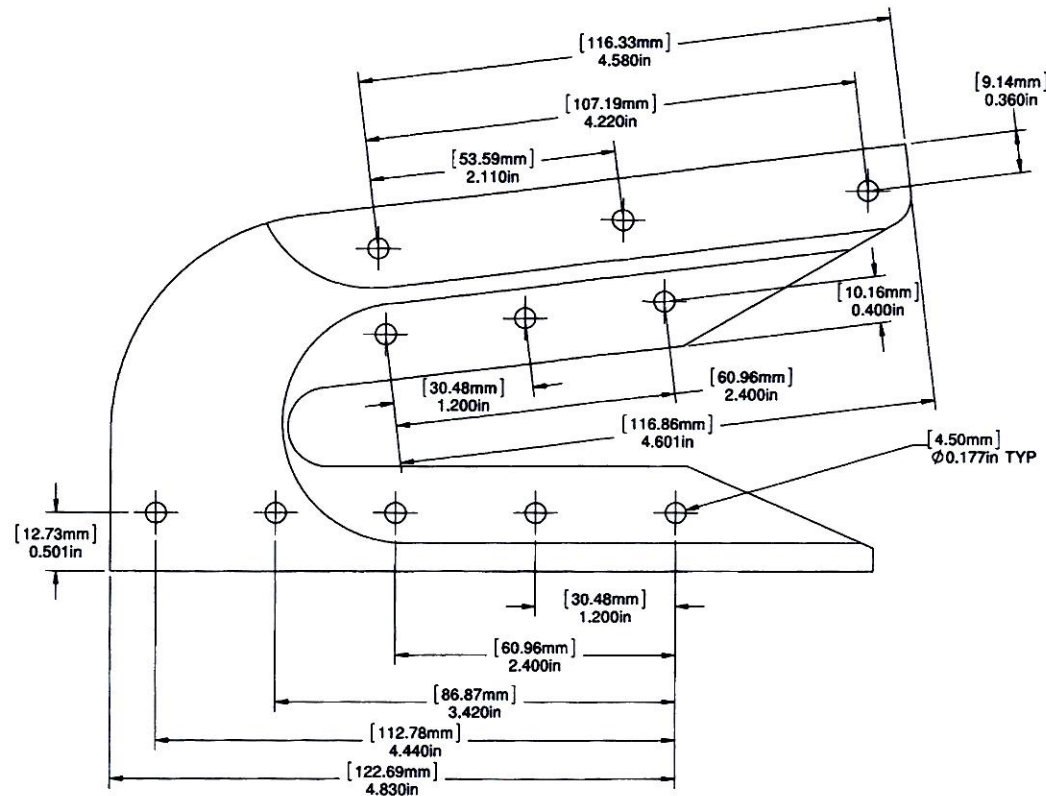
RELEASED
2013-10-31

NOTES:

- 1) MATERIAL: 7075-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/9 (OR AMS 4122/4123/4186/4187) OR
PER AMS-QQ-A-200/11 (REF DART SPEC M7075T6B)
- 2) FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK, AS PER QSI 017;
PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED, ALL METRIC DIMENSIONS ARE REFERENCE DIMENSIONS.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.49 lbs (0.22 kgs)
- 8) PART DIMENSIONS CONTROLLED BY CAD MODEL FILE: D4842-3-b.IGES

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED	A.P.	DRAWING NO.	REV. B
MFG. APPR.	2/	D4842	SHEET 3 OF 6
APPROVED	1/2	TITLE	SCALE
DE APPR.	1/2	LOWER CUTTER ASSY	NTS
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8 7 6 5 4 3 2 1



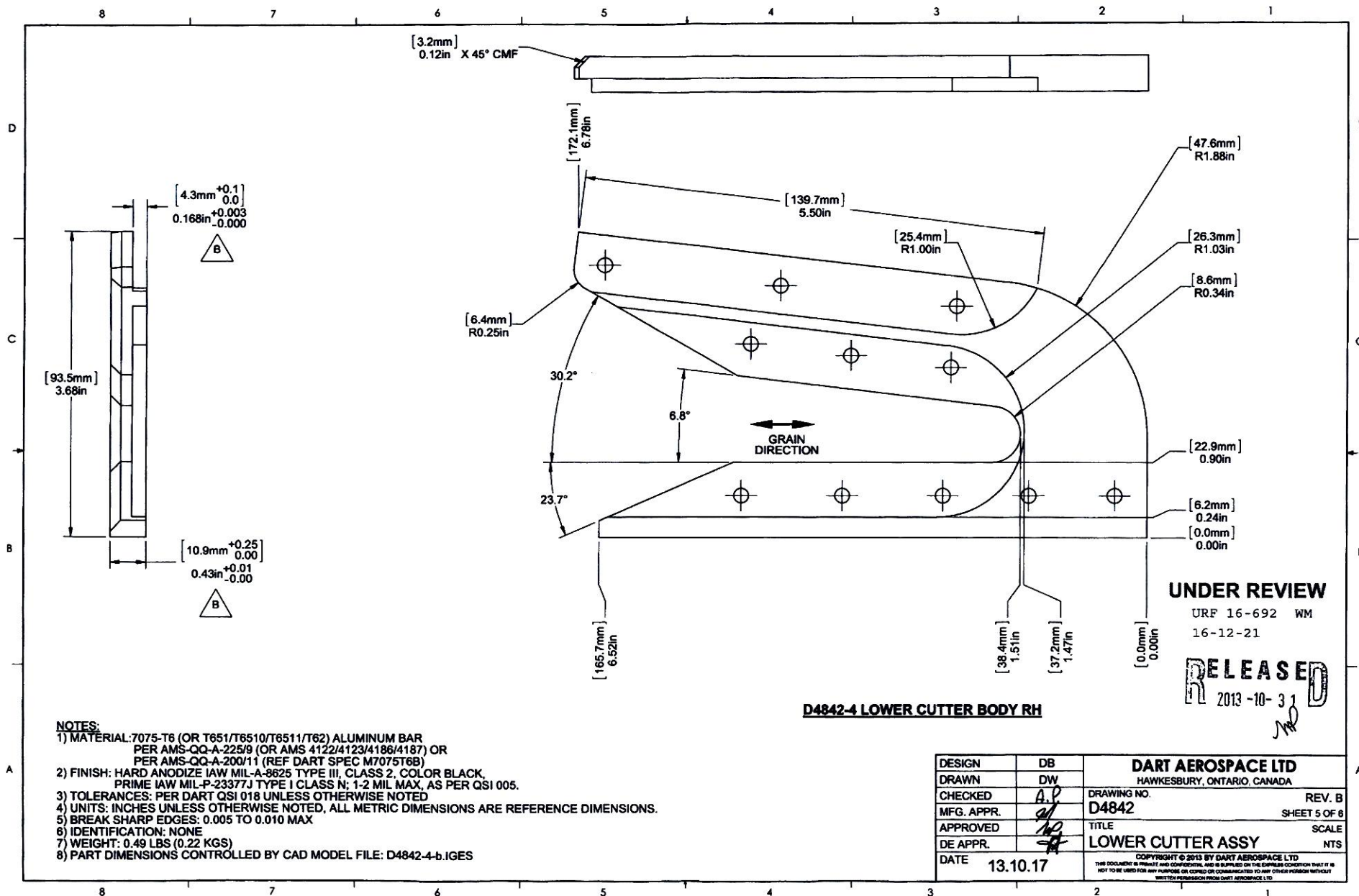
D4842-3 LOWER CUTTER BODY LH
(AUXILIARY VIEW)

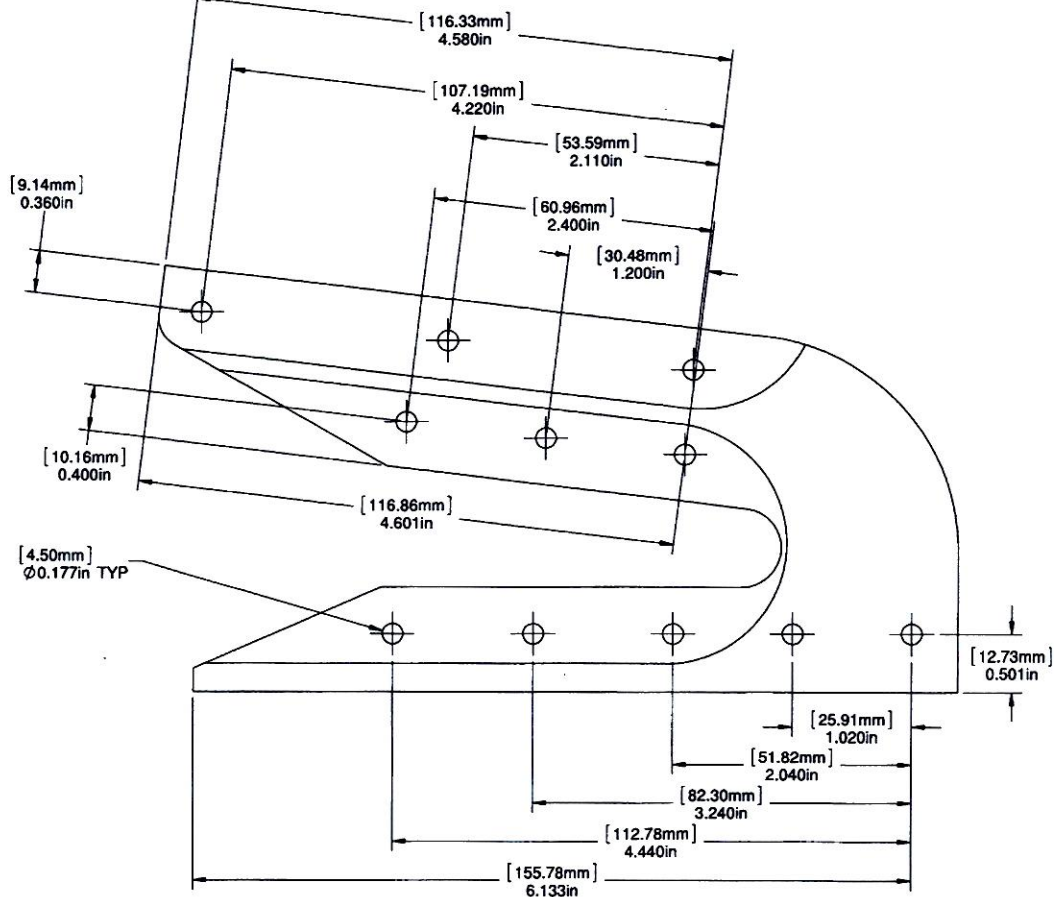
UNDER REVIEW

URF 16-692 WM
16-12-21

RELEASE
2013-10-31
W

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED	A.P.	DRAWING NO. D4842	REV. B
MFG. APPR.	W		SHEET 4 OF 6
APPROVED	W	TITLE	SCALE
DE APPR.	W	LOWER CUTTER ASSY	NTS
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D4842-4 LOWER CUTTER BODY RH
(AUXILLIARY VIEW)

UNDER REVIEW

URF 16-692 WM
16-12-21

RELEASE
2013-10-31

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DW	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO. D4842	REV. B
MFG. APPR.	al	SHEET 6 OF 6	
APPROVED	al	TITLE	SCALE
DE APPR.	al	LOWER CUTTER ASSY	NTS
DATE	13.10.17	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

 AgustaWestland A Finmeccanica Company		CONCESSION				Pag. 1 of 2	
Manuf. Doc. N.	AWC 006	Date		AW Doc. N.		Purchase Order	4800671131 4800722284 4801147764 4801186922 4801218851 4801288960 4801373666
AW P/N	6F9540V00231	S/N / Batch Number	B109195 Qty. (1) B133355 Qty. (2) B134314 Qty. (1) B134315 Qty. (1) B134842 Qty. (1) B137492 Qty. (1) B137355 Qty. (2) B137816 Qty. (1) B137818 Qty. (1) B137817 Qty. (1) B140379 Qty. (3) B140381 Qty. (2) B147002 Qty. (2) B150786 Qty. (1)	Grade	A	AW Drawing Issue	B
Description	Lower Cutter Assy			Batch Q.ty	20	Defective Q.ty	20
Manufacturer	Dart Aerospace			Model	AW169		
Defect(s) Description							
Leonardo has informed Dart that there are interference issues installing the lower cable cutter D4842-041 onto the Leonardo interface bracket.							
				Department	Inspector	Signature	Date
				Quality			
Defect(s) Cause							
The Lower Cutter body has a dimension of 10.9 +0.25/-0.00 mm. This dimension was reported as part of the approved FAI and has been met with all delivered product.							
				Department	Inspector	Signature	Date
				Quality			
Corrective Action						Complete Before	
In order to mitigate the interference issue for Leonardo, Dart is proposing to remove sufficient material to make the overall installation dimension at 22.15 mm +0.05/-0.35.							
				Department	Inspector	Signature	Date
				Quality			

For "MANUFACTURER" SUPPLIERS ONLY
ENGINEERING evaluation and proposal

Engineering evaluation

Investigation report

n.....

Compliance report

n.....

Dart's position is that this change will not impact the structural substantiation presented in Report DA169-4 for the lower cutter body since this is not a section with the lowest margin. Therefore removing 0.3 mm max from each part will not impact the structural integrity of the lower cutter assembly. The dimension on the cutter body part D4842-3/-4 will be 10.80 +0.00/-0.200.

The dimension change of the two lower cutter body parts mating, plus the sealant, anodize and primer layers will be defined as a dimension of 22.15 +0.05/-0.35 mm on the assembled lower cutterbody and will be incorporated into the D4842 drawing for inspection.

Defect effects			Limitations	
	Before any repair	After any repair		
	☐ yes	☐ yes ☐ no	☐ yes (specify) ☒ no	
Safety	☐ yes	☐ yes ☐ no		
Life	☐ yes	☐ yes ☐ no		
Strength	☐ yes	☐ yes ☐ no		
Performances	☐ yes	☐ yes ☐ no		
Interchangeability	☐ yes	☐ yes ☐ no		
Reliability	☐ yes	☐ yes ☐ no		
Maintainability	☐ yes	☐ yes ☐ no		
Installability	☒ yes	☐ yes ☒ no		
Testability	☐ yes	☐ yes ☐ no		
Only aspect	☐ yes	☐ yes ☐ no		
Repair Proposal		Decision to use		
None		☐ Use repaired with specific repair		
		☐ Use repaired with known repair		
		☐ Use as is		
		☐ Use repaired for tests (see Limitations)		
		☐ Use as is for tests (see Limitations)		
		☒ Scrap		
Concession Classification	☒ Major ☐ Minor	Submit after repair	☐ yes ☐ no	

PRINTING DATE AND STATUS 14.02.2017 Assigned to QC repair result

		Supplier Concession				PAGE 2 of 2	PLANT Leonardo Helic. - Vergiate
Supplier NC N.	AWC 006/01	Date	02.02.2017	AW	400000061786	Purchase Order	4801373666
DEFECT 0001 FO01 Wrong dimensions attachment							

Manuf. Doc. N.	AWC 006	Date		AW Doc. N.		Purchase Order	4800671131 4800722284 4801147764 4801186922 4801218851 4801288960 4801373666								
AW P/N	6F9540V00231	S/N / Batch Number	B109195 Qty. (1) B133355 Qty. (2) B134314 Qty. (1) B134315 Qty. (1) B134842 Qty. (1) B137492 Qty. (1) B137355 Qty. (2) B137816 Qty. (1) B137818 Qty. (1) B137817 Qty. (1) B140379 Qty. (3) B140381 Qty. (2) B147002 Qty. (2) B150786 Qty. (1)	Grade	A	AW Drawing Issue	B								
Description	Lower Cutter Assy			Batch Q.ty	20	Defective Q.ty	20								
Manufacturer	Dart Aerospace			Model	AW169										
Defect(s) Description															
Leonardo has informed Dart that there are interference issues installing the lower cable cutter D4842-041 onto the Leonardo interface bracket. <table border="1"> <thead> <tr> <th>Department</th> <th>Inspector</th> <th>Signature</th> <th>Date</th> </tr> </thead> <tbody> <tr> <td>Quality</td> <td>DAS 16 9-89</td> <td></td> <td>2017/02/01</td> </tr> </tbody> </table>								Department	Inspector	Signature	Date	Quality	DAS 16 9-89		2017/02/01
Department	Inspector	Signature	Date												
Quality	DAS 16 9-89		2017/02/01												
Defect(s) Cause															
The Lower Cutter body has a dimension of 10.9 +0.25/-0.00 mm. This dimension was reported as part of the approved FAI and has been met with all delivered product. <table border="1"> <thead> <tr> <th>Department</th> <th>Inspector</th> <th>Signature</th> <th>Date</th> </tr> </thead> <tbody> <tr> <td>Quality</td> <td>DAS 16 9-89</td> <td></td> <td>2017/02/01</td> </tr> </tbody> </table>								Department	Inspector	Signature	Date	Quality	DAS 16 9-89		2017/02/01
Department	Inspector	Signature	Date												
Quality	DAS 16 9-89		2017/02/01												
Corrective Action						Complete Before									
In order to mitigate the interference issue for Leonardo, Dart is proposing to remove sufficient material to make the overall installation dimension at 22.15 mm +0.05/-0.35. <table border="1"> <thead> <tr> <th>Department</th> <th>Inspector</th> <th>Signature</th> <th>Date</th> </tr> </thead> <tbody> <tr> <td>Quality</td> <td>DAS 16 9-89</td> <td></td> <td>2017/02/01</td> </tr> </tbody> </table>								Department	Inspector	Signature	Date	Quality	DAS 16 9-89		2017/02/01
Department	Inspector	Signature	Date												
Quality	DAS 16 9-89		2017/02/01												



For "MANUFACTURER" SUPPLIERS ONLY

ENGINEERING evaluation and proposal

Engineering evaluation

Investigation report
Compliance report

n.....
n.....

Dart's position is that this change will not impact the structural substantiation presented in Report DA169-4 for the lower cutter body since this is not a section with the lowest margin. Therefore removing 0.3 mm max from each part will not impact the structural integrity of the lower cutter assembly. The dimension on the cutter body part D4842-3/-4 will be 10.80 +0.00/-0.200.

The dimension change of the two lower cutter body parts mating, plus the sealant, anodize and primer layers will be defined as a dimension of 22.15 +0.05/-0.35 mm on the assembled lower cutterbody and will be incorporated into the D4842 drawing for inspection.

Defect effects			Limitations	
	Before any repair	After any repair		
Safety	☐ yes	☐ yes ☐ no	☐ yes (specify) ☒ no	
Life	☐ yes	☐ yes ☐ no		
Strength	☐ yes	☐ yes ☐ no		
Performances	☐ yes	☐ yes ☐ no		
Interchangeability	☐ yes	☐ yes ☐ no		
Reliability	☐ yes	☐ yes ☐ no		
Maintainability	☐ yes	☐ yes ☐ no		
Installability	☒ yes	☐ yes ☒ no		
Testability	☐ yes	☐ yes ☐ no		
Only aspect	☐ yes	☐ yes ☐ no		
Repair Proposal None			Decision to use ☐ Use repaired with specific repair ☐ Use repaired with known repair ☐ Use as is ☐ Use repaired for tests (see Limitations) ☐ Use as is for tests (see Limitations) ☒ Scrap	
Concession Classification		☒ Major ☐ Minor	Submit after repair	☐ yes ☐ no